

123550

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/08/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/15/14 **Req'd Qty:** 1.00 ***1***

Customer:

Approvals:

Process Plan:

Date:

Tooling:**Date:**

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

Work Order ID 123550

123550

Page 3

August-08-14 7:58:47 AM

Item ID: D4486-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Access Panel Assembly, LH
 Start Date: 8/08/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/15/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						1	14-08-11	DMC	
HandFinish	Memo	0.00							
Hand Finishing									
165	QC7-Inspect Chemical Conversion Coat	0.00							
165			DAS						
QC	Memo	0.00	16						
Quality Control			9-89	W/09/12		(81)			
						-071			
166		0.00							
166						1			
SprayPaint	Memo	0.00							
Spray Painting	Prime tempo grey as per dwg (note 2, sheet 2)								
	Batch: 128927								
									DAS 41 9-89 14-8-15

Work Order ID 123550

August-08-14 7:58:47 AM

123550

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Item ID: D4486-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Access Panel Assembly, LH
 Start Date: 8/08/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/15/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>ST236</u>	0.00							
190									
Packaging	Memo	0.00				<u>1X</u>	<u>DAS</u> <u>28</u> <u>9-89</u>	<u>AUG 27 2014</u>	
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-28
MLJ 1408-28

Picklist Print

August-08-14 7:58:46 AM

Page 1

Work Order ID: 123550

123550

Parent Item: D4486-041

D4486-041

Parent Item Name: Access Panel Assembly, LH

Start Date: 8/08/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 12.02.02 new issue EC verified by DD
12.12.04 AS PER DWG REV.C DD VERF:JLM
REV D JLM 13-02-11 VERIFIED BY:DD
IPP REV:B
IPP REV:C AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

837.0880

0.64

1

DAS
23
9-89

M6061T6S 063

6061-T6 .063 Sheet

**

14-08-8

Location

Loc Qty

Loc Code

MAT021

584.088

M127420

111.12

M128054

63.468

M128941

28

M129636

183

M129845

81.5

M129881

117

TPI

253

M129637

253

MS20426AD3-3

Purchased

No

Each

4,744.000

18

DAS
36
9-89

MS20426AD3-3

RIVET

**

14/08/25

Location

Loc Qty

Loc Code

ST315

4744

123352

344

M128754

4400

MS21069L08

Purchased

No

Each

1,800.000

9

DAS
36
9-89

MS21069L 08

ANCHOR NUT

**

14/08/25

Location

Loc Qty

Loc Code

ST304

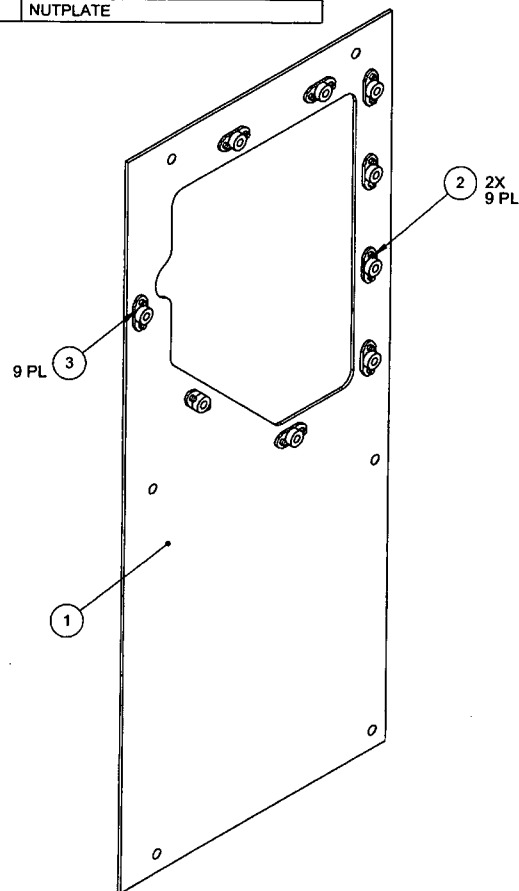
1800

123522

1800

9

ITEM	QTY	P/N	DESCRIPTION
	X	D4486-041	ACCESS PANEL ASSY (LH)
1	1	D4486-1	ACCESS PANEL (LH)
2	18	MS20426AD3-3	RIVET, CSK
3	9	MS21069L08	NUTPLATE



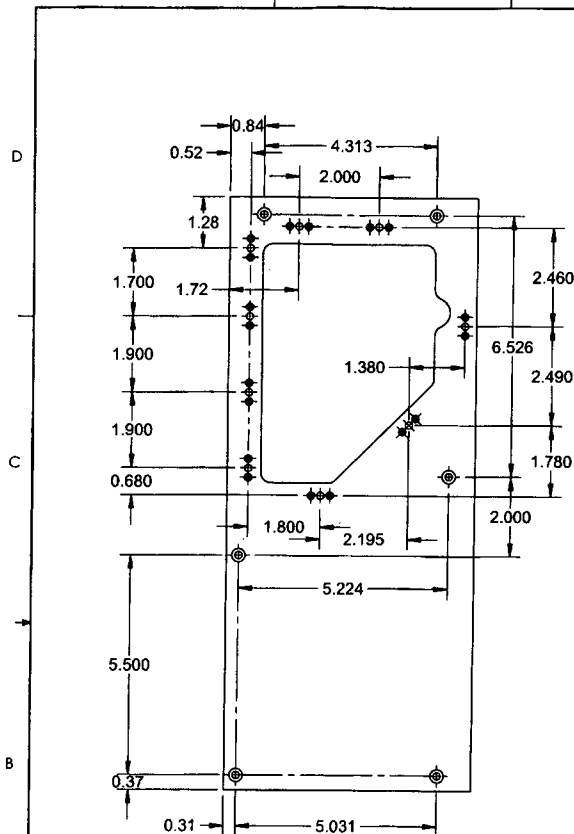
D4486-041 ACCESS PANEL ASSY (LH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

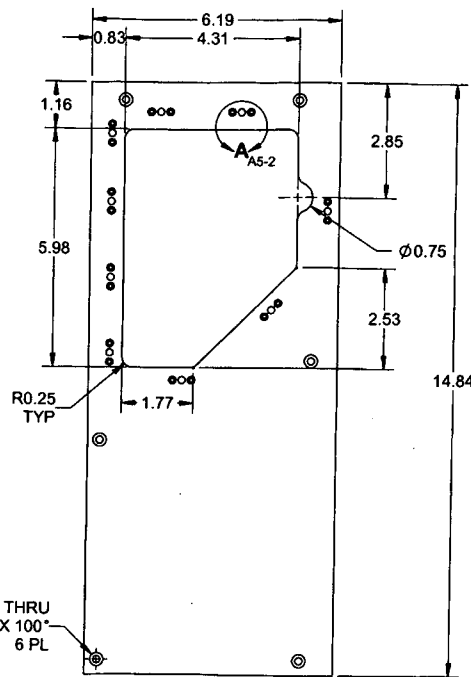
D4486-3 FWD ACCESS PANEL (LH)

D	ADDED -4, INSTALLATION HOLES ALL CHANGED TO COUNTERSUNK, MULTIPLE DIMENSIONS CHANGED FOR RELOCATION OF LATCH ASSY AT NEXT ASSEMBLY.	AJS	12.12.13
C	ADDED -042 & -2 (RH CONFIGURATION)	AJS	12.10.17
B	COMPLETE REDESIGN. MATERIAL WAS 0.032 THICK.	AJS	12.09.11
A	NEW ISSUE	AJS	12.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	AS	D4486	SHEET 1 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	ACCESS PANEL ASSY	NTS
DATE	12.12.13	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

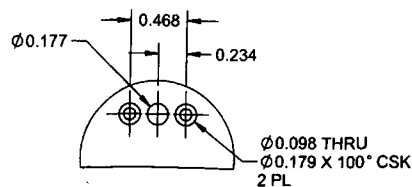


D4486-1 ACCESS PANEL (LH)

Δ
 $\phi 0.183$ THRU
 CSK $\phi 0.332 \times 100^\circ$
 6 PL

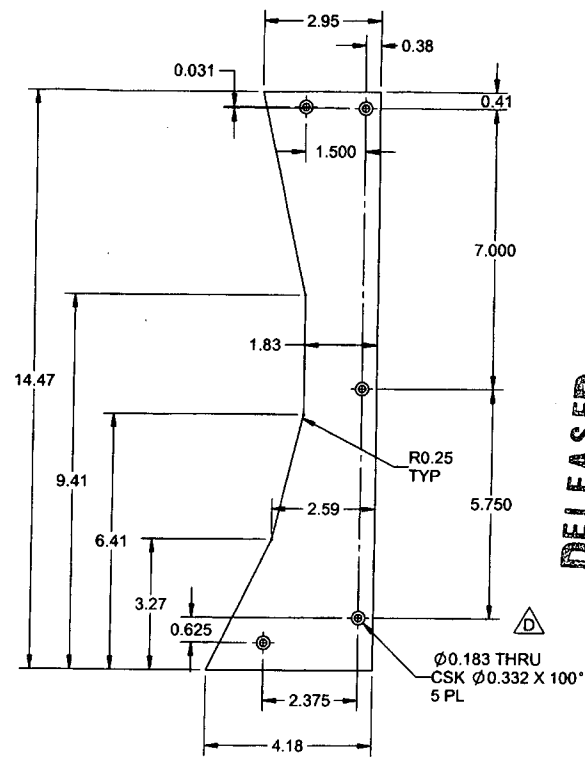


(SUPPLEMENTAL VIEW)



DETAIL A D5-2
 NUTPLATE HOLE DETAIL 9PL
 (SCALE 2X)

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
 PER AMS 4025 OR AMS 4027 OR ASTM B209
 REF M6061T6S.063
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.42 lbs
 - 8) DELETED AT REVISION B



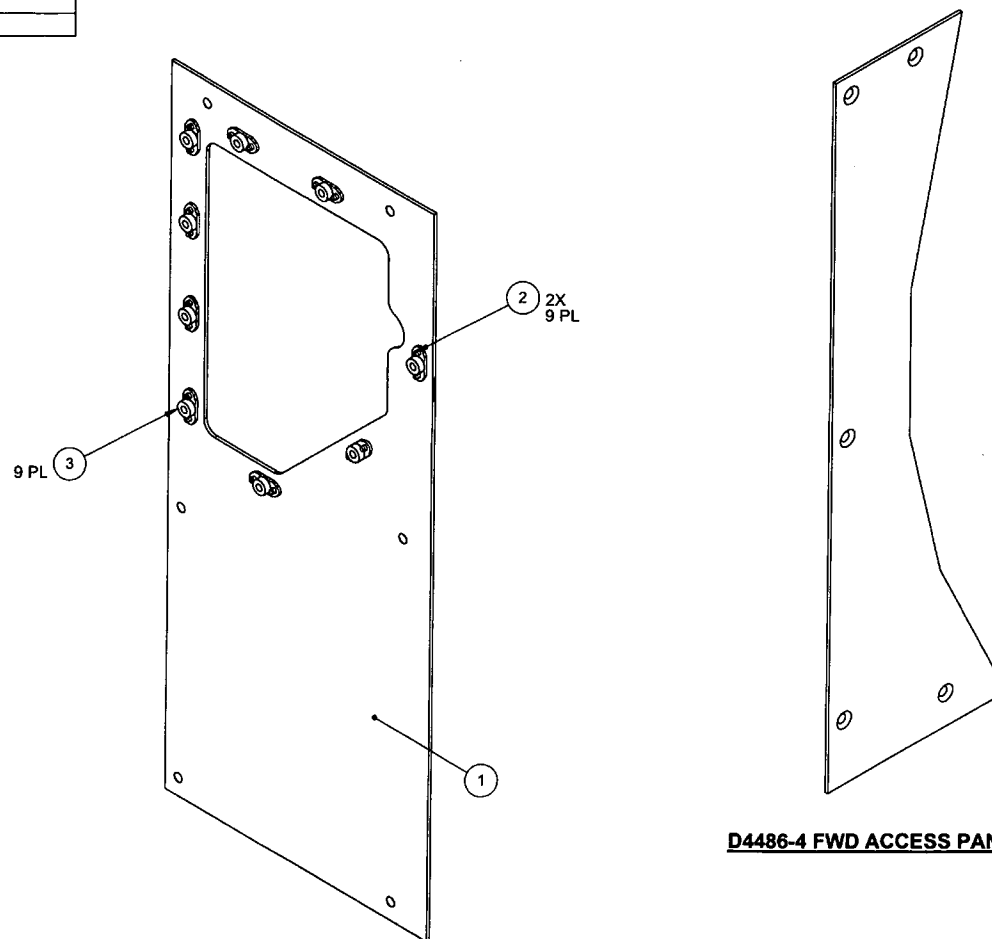
D4486-3 FWD ACCESS PANEL (LH)

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
 PER AMS 4025 OR AMS 4027 OR ASTM B209
 REF M6061T6S.063
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.22 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	AP	D4486	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ACCESS PANEL ASSY	NTS
DATE	12.12.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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RELEASED
 2013-02-08

ITEM	QTY	P/N	DESCRIPTION
	X	D4486-042	ACCESS PANEL ASSY (RH)
1	1	D4486-2	ACCESS PANEL (RH)
2	18	MS20426AD3-3	RIVET, CSK
3	9	MS21069L08	NUTPLATE



D4486-042 ACCESS PANEL ASSY (RH)

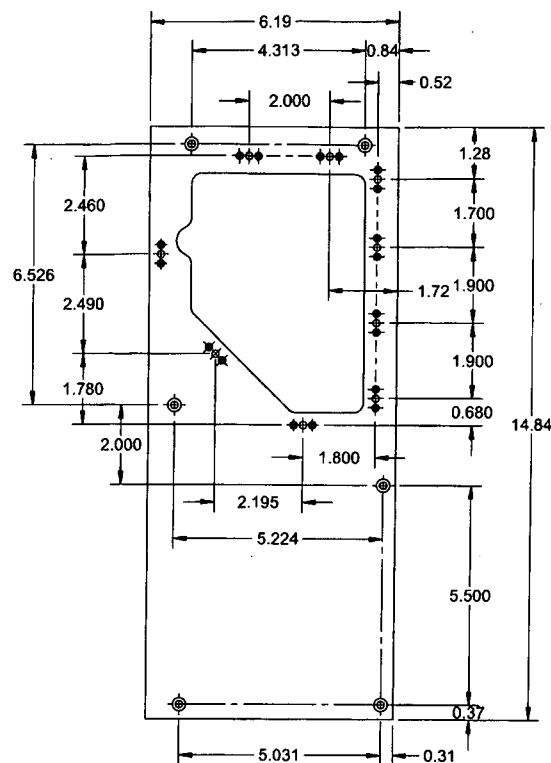
D4486-4 FWD ACCESS PANEL (RH)

RELEASED
2013-02-08
ND

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

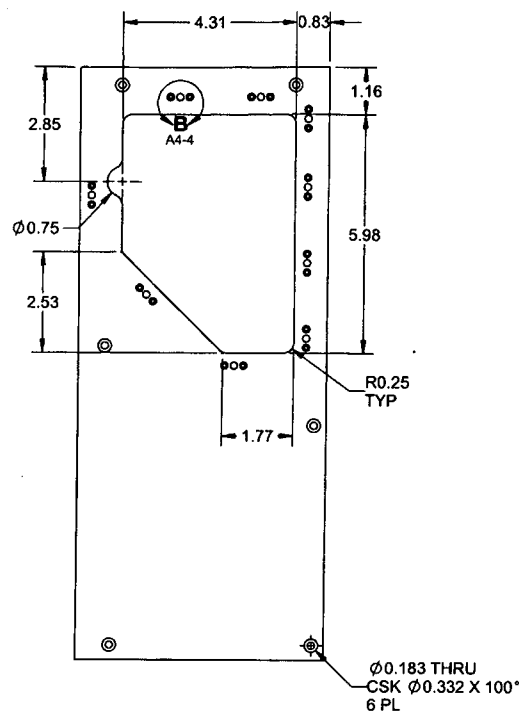
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	SS	D4486	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	CH	ACCESS PANEL ASSY	NTS
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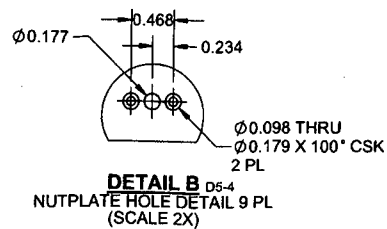
D4486-2 ACCESS PANEL (RH)

NOTES:

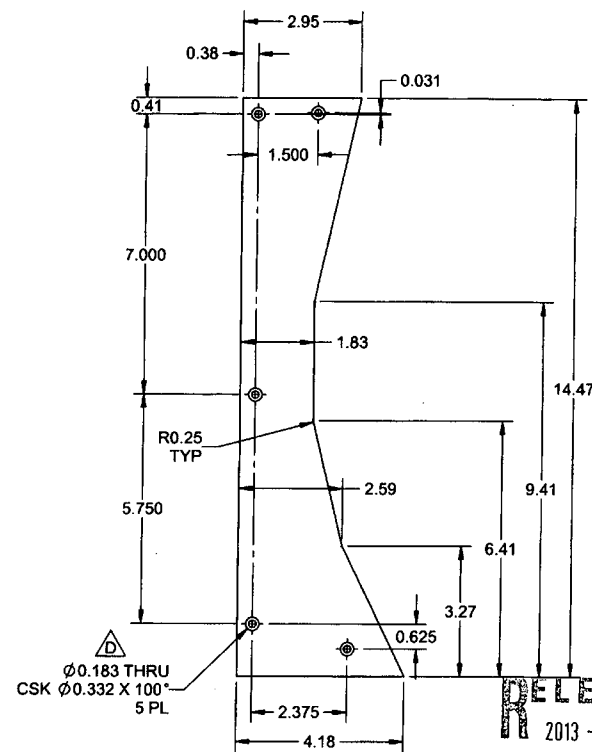
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) NOTE 8 NOT TO BE USED



(SUPPLEMENTAL VIEW)



DETAIL B D5-4
NUTPLATE HOLE DETAIL 9 PL
(SCALE 2X)



D4486-4 FWD ACCESS PANEL (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	N	D4486	SHEET 4 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ACCESS PANEL ASSY	NTS
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DART AEROSPACE LTD		Work Order: 123550 123228
Description: Access Panel RH		Part Number: D4486-2
Inspection Dwg: D4486	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.098"	+0.005-0.001	0.098"	-		✓	Jrma
Ø 0.177"	+0.005-0.001	0.177"	-		✓	
Ø 0.183"	+0.005-0.001	0.183"	-		✓	
0.468"	+0.010"	0.468"	-		✓	
0.234"	"	0.236"	-		✓	
5.031"	"	5.034"	-		✓	
5.500"	"	5.502"	-		✓	
5.224"	"	5.222"	-		✓	
2.195"	"	2.193"	-		✓	
1.800"	"	1.804"	-		✓	
0.680"	"	0.685"	-		✓	
2.000"	"	2.002"	-		✓	
1.900"	"	1.905"	-		✓	
1.700"	"	1.70	-		✓	
2.490"	"	2.49	-		✓	
2.460"	"	2.46	-		✓	
6.526"	"	6.52	-		✓	
2.000"	"	2.00	-		✓	
6.19"	+0.030"	6.10	-		✓	
14.84"	"	14.85	-		✓	Jrma

NOTE
JMA
14/08/17

Measured by: DAS 23 9-89	Audited by: DAS 38 9-89	Preliminary Approval:
Date: 14-08-8	Date: 14/08/17	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15